

Date: Thursday, 2/7/2008 10:53:48 AM
 User: Kim Johnston

Process Sheet

10

Customer : CU-DAR001, Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY RH
 Job Number : 37279
 Estimate Number : 10268
 P.O. Number :
 This Issue : 2/7/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D350636014
 First Issue : 1/1 Type : LANDING GEAR Drawing Number : D2750 REV E
 Previous Run : 37278 Drawing Revision : E
 Material :
 Due Date : 3/6/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment :
 Est Rev: H 02.09.25 Rearranged procedure steps KJ
 Est Rev: I 05.12.08 Rearranged procedure steps EC
 Est Rev: J 06.03.30 Per rev. D EC
 Est Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM
 Verified By: EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-014 CHG 003

508/02/07 08.02.14

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2600-3-Bent

Extrusion (Bent)

B 35527

① N 8-2-20

3.0 D2744 Fwd Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch:

B 33996

BE 08/02/21

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2- Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details). Drill using drill Jig DT8150 & DT8864 drilling holes labelled "B" only.

8-2-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description:

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8864 and cut as per dwg D2750.

4-Drill pilot holes for Detail B using DT8330

5-Open up holes for Detail B, "hole size W" and blade fitting location holes to 0.500" (total of 9 holes per side) as per dwg D2750.

6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.297" ***Make sure that wearplate holes are on bottom of tube*****

7-Open up holes of Detail A to 0.250" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod *M 100330 BE 08/02/21*

10-Grind welds flush as per Dwg D2750 *M 8-2-25*

~~11-Countersink Detail A as per dwg D2750.~~

8-2-20

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

ID 08-02-26

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

for 27 @

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

D M 8-2-4

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Am 08.03.04 @

9.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Web

Batch: *B 36371*

(1) M 8-3-4

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Job Number: 37279

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description:

10.0

D34901

CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch:

33824

BE 08/03/05

11.0

D34905

CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch:

32597

BE 08/03/05

12.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Crossbolt Spacer

Batch:

36030

BE 08/03/05

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open up holes "size X" (total of 4 holes per side) as per dwg D2750

2-Open up holes of Detail V & Detail C to 0.625" (total of 8 holes per side)
as per dwg D2750.

3-Chamfer holes of Detail V, Detail C, hole size "W" and "X" per dwg D2750 (welding instructions on sheet 5)

4-Deburr and blow out all chips from inside of tube

5-Bond web D2739 in place as per QSI 015

A/R

Sikaflex-291

batch:

M105525

exp. date:

8-7-31

6- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 5)

A/R

Aluminum Rod

batch:

M106762

BE 08/03/05

7-Grind welds flush as per Dwg D2750

G.M.

08.03.05

①

K
8-3-4

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Job Number: 37279

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description:

10-Spot face ground handling holes section J-J (total of 4 places per side) as per dwg D2750

a.m 08.03.05 ①

11-Deburr holes

a.m 08.03.05 ①

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

D 08.03.06 ①

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/06 ①

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

M-L

08/03/06 ①

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

M 107005

M-L 08/03/07 ①

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

Hf

08-03-07 ①

19.0

ALS41032225

Insert



Comment: Qty.: 42.0000 Each(s)/Unit Total: 42.0000 Each(s)

Insert

Batch: M100489

Hf

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts as per dwg D2750

Hf

08-03-07 ①

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Job Number: 37279

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description:

21.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bushing (5X) = 1334817

Batch: (3X) = 1334817

same batch

JM

22.0

D353513

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch: 1336423

JM

23.0

D353525

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch: 1336424

JM

24.0

D353535

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch: 1336425

JM

25.0

D353613

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: 1336635

JM

26.0

D353625

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: 1336636

JM

27.0

D353635

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET 1336609

JM

08-03-07

(X1)

W/O:		WORK ORDER CHANGES					
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Job Number: 37279

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description:

28.0

D35371

WEARPAD



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

WEARPAD

Batch: B36714

JS

29.0

D36311

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

WASHER

Batch: B34276

JS

30.0

D3488042

BLADE FITTING ASSEMBLY, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Blade Fitting, RH

Batch: B35587

JS

31.0

D3492041

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B36123

JS

32.0

D3492045

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

PLUG ASSEMBLY (5x1) => B32599

Batch: (3x) => B33425

JS

33.0

AN3C5A

Bolt



Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)

Bolt

Batch: M106780

JS

34.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M105360

JS

08-03-07

(X)

W/O:		WORK ORDER CHANGES					
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Job Number: 37279

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

AN3C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M105906

91

36.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M106662

91

37.0

AN8C35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: M102671

91

38.0

AN960C10L

washer



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

washer

Batch: M107242

91

39.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M106513

91

40.0

MS210436

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

NUT

Batch: M103693

91

41.0

MS21083C8

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

NUT

Batch: M106431

91

08-03-07

(X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 37279

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description:

42.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

WASHER

Batch: ~~91-2~~ M105430 M1106516 M1

43.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: M1105430

M1

44.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

- 08-03-10 (X) M1
- ✓ 1-Assemble tube hardware as per dwg D2750 sikaflex batch: M105585 08/07
 - ✓ 2-Inspect For Foreign Objects
 - ✓ 3-Spray inside of tube with "LPS-3" batch: M105005
 - 4-Install blade fitting D3488-041, wearshoe
SIKA FLEX 241
BATCH: M1105585
EXP DATE: 08/07
 - ✓ 5-Coat all exposed fasteners with "LPS Procyon" batch: M1104251
- M1 08-03-10 (X)

45.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

46.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 37279

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

D2741

Blade



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Blade
Batch: 1735435

SC

48.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
Batch: 1107513

M107520

SC

49.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Nut
Batch: M106431

SC

50.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
Batch: M105160

SC

51.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
WASHER
Batch: M107520

M107581

SC

52.0

D34931

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
WASHER
Batch: 1736034

8/3/11

SC

(X)

53.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/04/11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number:



Seq. #:

Machine Or Operation:

Description :

54.0

PACKAGING 1

PACKAGING RESOURCE #1



Rev 4 8/4/1



50(1x)

Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-014

Loc 72

80

55.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/02

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-01

u

B37279

W/O:		WORK ORDER CHANGES					
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DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2750	REV. E SHEET 2 OF 5
DATE 07.05.17		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

GENERAL NOTES:

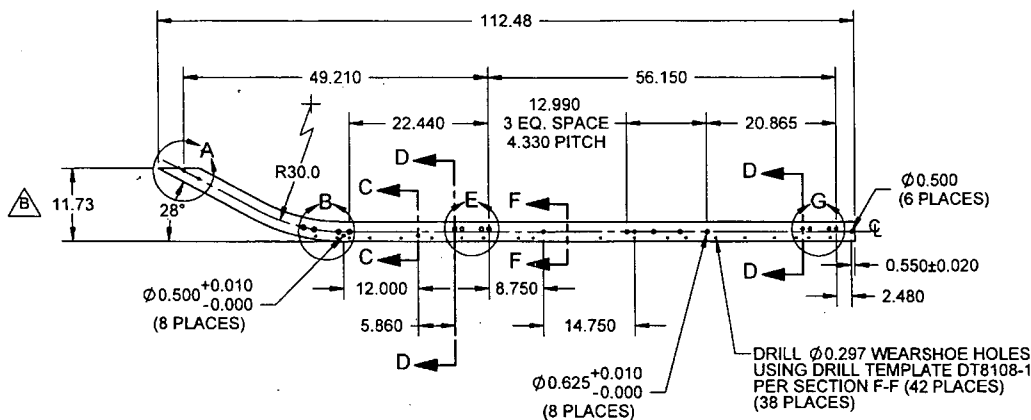
RELEASED
07-08-02 *[Signature]*

1. ALL DIMENSIONS ARE IN INCHES.
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS C-C, D-D AND F-F.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'F' SIZE HOLES ($\emptyset 0.297$) FOR WEARSHOE INSERTS.
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3C5A/AN3C7A WEARSHOE BOLTS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

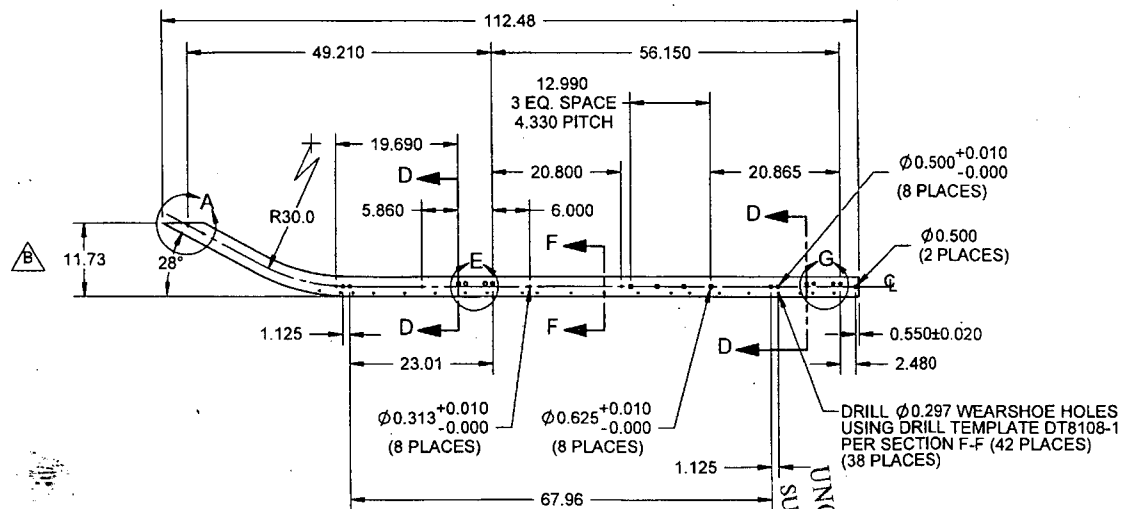
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
37279

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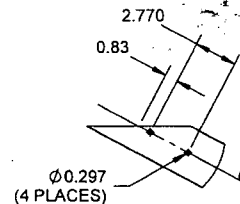
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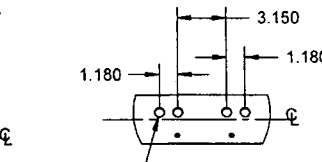
D2750-1 LH SKIDTUBE (SHOWN)
D2750-2 RH SKIDTUBE (OPPOSITE)



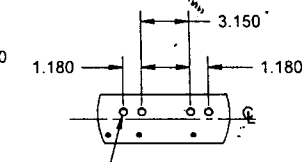
D2750-3 LH SKIDTUBE (SHOWN)
D2750-4 RH SKIDTUBE (OPPOSITE)



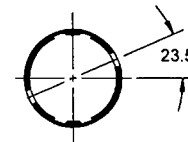
DETAIL A
SCALE 1:8



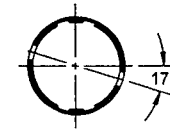
DETAIL E
SCALE 1:8



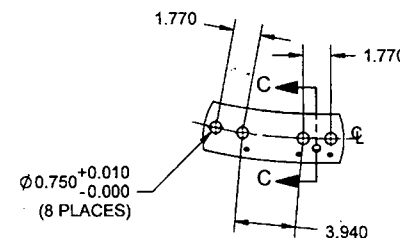
DETAIL G
SCALE 1:8



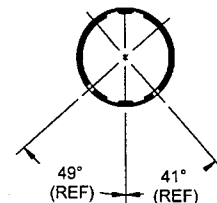
SECTION C-C
SCALE 1:4



SECTION D-D
SCALE 1:4




DETAIL B
SCALE 1:8
(ALL DIMENSIONS ARE
STRAIGHT LINE DIMENSIONS)



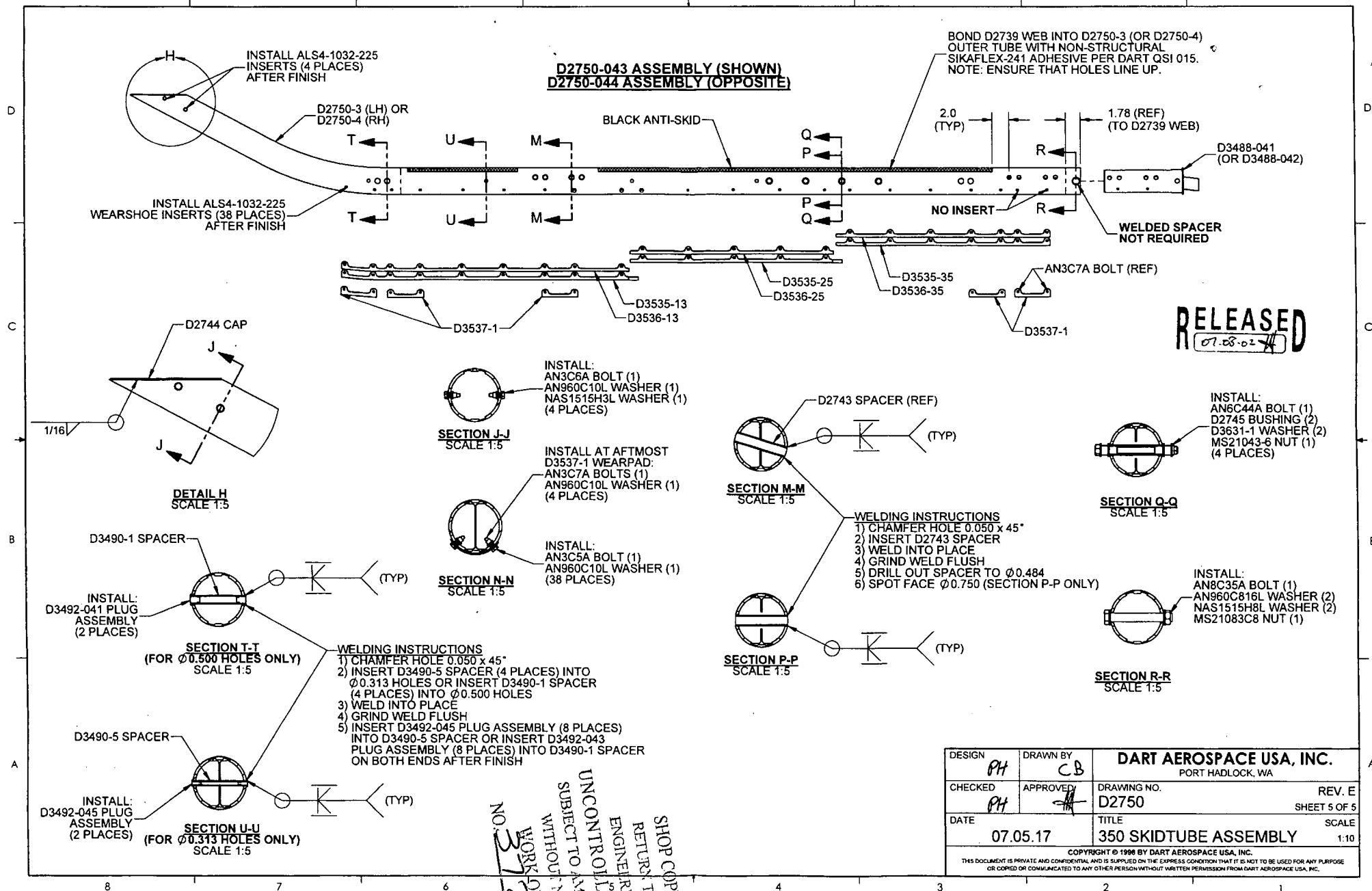
SECTION F-F
SCALE 1:4

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				D2750	SHEET 3 OF 5
DATE	07.05.17			TITLE	SCALE
				350 SKIDTUBE ASSEMBLY	1:20
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		TITLE	350 SKIDTUBE ASSEMBLY	SCALE	1:10
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AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay E
Joint Welding Procedure GTAW
Part number and Job number D35063604 / B37279

TEST WELDS REQUIRED

BASE METAL Aluminum WELDING PROCESS TIG
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position		Vertical Down <input type="checkbox"/> Up <input type="checkbox"/>	
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into N/A Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 08-03-06

Qualifier Pat Diwel